

Work Order ID 142259***142259***

Page 1

Friday, March 04, 2016 7:37:07 AM

Item ID: D6104-005 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Round Billet, 17-4
Start Date: 3/4/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 3/18/2016 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D6104	Rev B								

100 PURCHASING 0.00 ***100*** 20 MAR 04 2016 DAS 13 9-89
Purchasing Memo 0.00

Purchasing Issue P/O: 31612 a) Description: S.S round billet b) Ø4.00" x 5.10" long c) Tolerance on all dimensions are +0.030"/-0.000" d) Material: 17-4PH Stainless steel (Ams 5643 or Aisi 630) e) One blank makes 2 parts f) Material certification required

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110 20x 8016-03-11
Packaging Memo 0.01
Packaging Ensure material certification is attached

120 QC18 In-Coming Inspection Material 0.00

120 20 16/03/15
QC Memo 0.00
Quality Control Ensure Material certification comply to Dwg D6104

Work Order ID 142259***142259***

Page 2

Friday, March 04, 2016 7:37:08 AM

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Revision ID: Stop ***NS2***
Item Name: Round Billet, 17-4
Start Date: 3/4/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 3/18/2016 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: MAT043	0.00							DAS 14 9-39
130						<u>20</u>	<u>0</u>		<u>16/03/15</u>
Packaging	Memo	0.00							
Packaging	LOCATION: MAT043								
140	QC21- Final Inspection - Work Order Release	0.00							<u>16/1/15</u> <u>JS</u>
140									
QC	Memo	0.03							
Quality Control									

MAR 15 2016

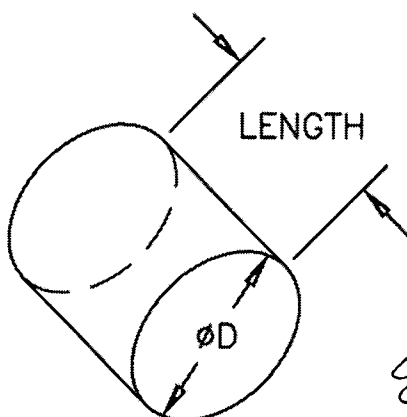
MC



DESIGN <i>RF</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6104	Rev. B SHEET 1 OF 1
DATE 02.11.25		TITLE ROUND BILLET, 17-4	SCALE NTS
A	01.04.10	NEW ISSUE	
B	02.11.25	CLARIFY ALLOY SPEC ADDED D6104-009/-011 REDUCE LENGTH OF BILLETS	

RELEASED
02.11.29 *[Signature]*

SPECIFICATION CONTROL DRAWING



MATERIAL: 17-4 PH SS (AMS 5643 OR AISI 630) MIN UTS = 170 KSI (38 HRc)

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES

Part No.	Alloy	D (Diameter)	Length
D6104-001	17-4 PH STAINLESS STEEL	Ø3.00	3.80
D6104-003	17-4 PH STAINLESS STEEL	Ø3.25	3.80
D6104-005	17-4 PH STAINLESS STEEL	Ø4.00	5.10
D6104-007	17-4 PH STAINLESS STEEL	Ø4.50	5.10
D6104-009	17-4 PH STAINLESS STEEL	Ø5.25	4.10
D6104-011	17-4 PH STAINLESS STEEL	Ø6.50	4.10

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31612**

Purchase Order Date 3/4/2016 1:31:27 PM

PO Print Date 3/4/2016

Page Number 1 of 2

Order From :

VU-MET002

METAUX CASTLE
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W OE9
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
MAR 04 2016

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						

D6104-005P

17-4 SS Roundbar 4.00"Od

3/18/2016

Yes

3/18/2016

20.00

Each

\$54.20

\$1,084.00

AS PER DWG D6104 REV. B
B142259

MATERIAL: 17-4 PH AS PER AMS 4643 OR AISI 630
SIZE: 4.00" X 5.10" LONG

SP 16-03-11

Line Total:

\$1,084.00

2 71401-45

PROCUREMENT
QUALITY CLAUSES

3/18/2016

1.00

\$0.00

\$0.00

No

3/18/2016

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

Note:

3/4/2016

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:2909026

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped	F.O.B.	Freight Terms		Carrier		BOL No	
09-MAR-16	ORIGIN	Prepaid		MANITOULIN		2909026-2	

Shipment Details	Final Destination Branch - TOR
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Order No 4276468	Line No 2	Item No 42464MO	Description 4.0000.RD.17CR-4NI STAINLESS.RT.SOL TR.COND A.132.0000-156.0000 CUT TO 5.1 IN (+ .1250/- .0000 IN) - BAND SAW CUTTING SPECIFICATIONS: AMS 5643 ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S Email P/s and certs to: clavoie@dartaero.com
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Purchase Order No 31612	Part Number YOUR ITEM NUMBER: D6104-005	Ordered Qty 13.00 PCS	Invoice Qty 13.00 PCS
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Details	ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS
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Delivery No. 120365792	Mill NORTH AMERICAN STAINLESS	Heat Number 	Mech Id	PCS 13	Width (IN)	Length (IN)	Shipped Qty(LBS) 243.4779
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A. M. Castle & Co.

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Page 2 of 2

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These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

Date:

Name:

[Handwritten signature]

MAR 09 2016



[Handwritten signature]



**NORTH AMERICAN
STAINLESS**

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 105025 02	Mail To: A.M. CASTLE AND COMPANY 1420 KENSINGTON ROAD-SUITE 220 OAK BROOK IL 60523	Ship To: A.M. CASTLE AND COMPANY 26800 MILES ROAD BEDFORD HEIGHTS OH 44146	Date: 10/15/2015 Page: 1 Of 1
Customer: 0032 005			Steel: 630(17-4)
NAS Order: LP 37916 1			Finish: Hot Finish
Your Order: 346085-1	Item Code: 42464		Dia/Thk: 4.0000 in
			Leg Length:
			Length: 144.00 in
			Corrosion:

PRODUCT DESCRIPTION:

AMS 2303F,
Round Bar, Hot Rolled, Annealed, Rough Turned
UNS S17400; EN 10204 3.1, ASTM A484/11, MACRO OK, AMS 5643T
ASTM A564/13, AMS 2303, ASME SA564-07, ASTM F899/11 (CHEM ONLY)
SOL. ANNEALED @ 1900F MIN FOR 1 HR MIN. and air cooled to RT
H900 MECH. PROPERTIES ARE CAPABILITY ONLY*

REMARKS:

COMPLIES W/REQUIREMENTS OF DFAR 252.225-7009 EU DIRECTIVE
2011/65/EU. RoHS. EAF+AOD+CC. NO WELD REPAIR. MELTED AND MFG
IN USA FREE FROM MERCURY AND LOW MELTING ALLOY CONTAMINATION

DAS
14
9-30

16/03/15

Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight
BH50373	2090	BH50382	2018					

Lab Accreditation Bureau, ISO/IEC 17025, Certificate# L2323

CHEMICAL ANALYSIS CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan) Chemical Analysis per ASTM A751/08

Heat	Supplier #	CM	C %	CB %	CO %	CR %	CU %	MN %	MO %	N %	NI %	P %
W5L9		US	.022	.176	.09	15.38	3.02	.77	.09	.027	4.21	.020
			S %	SI %	TA %	TI %						
			.0285	.62	.0080	.0020						

MECHANICAL PROPERTIES

	1 d o i c r	HB No.	Grain No.	Ferrite %	TS-900CAP KSI	YS-900CAP KSI	EL-900CAP % 4D	RA-900CAP %	RC-900CAP No.	FREQ. No.	SEV. No.
BH50373	R L	341.0	8.0	.10	200.24	175.93	12.88	44.20	42.5	.20	.11
BH50382	R L	341.0	8.0	.10	200.24	175.93	12.88	44.20	42.5	.20	.11



NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS

Technical
Dept. Mgr.

ABHJEET BHAVE

ABHJEET BHAVE

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:2909026

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 09-MAR-16	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 2909026-2	

Shipment Details	Final Destination Branch - TOR
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Order No 4276468	Line No 1	Item No 42464.MO	Description 4.0000.RD.17CR-4NI.STAINLESS.RT.SOL TR.COND A.132.0000-156.0000 CUT TO 5.1 IN (+ .1250/- .0000 IN) - BAND SAW CUTTING SPECIFICATIONS: AMS 5643 ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S Email P/s and certs to: clavoie@dartaero.com
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Purchase Order No 31612	Part Number YOUR ITEM NUMBER: D6104-005	Ordered Qty 7.00 PCS	Invoice Qty 7.00 PCS
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Details	ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS 
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Delivery No. 120365791	Mill NORTH AMERICAN STAINLESS	Heat Number 	Mech Id	PCS 7	Width (IN)	Length (IN)	Shipped Qty(LBS) 131.1035
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A. M. Castle & Co.

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Page 2 of 2

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Reviewed by Authorized Castle Metals Representative:

Date:

Name:

MAR 09 2016



6076-B-11



NORTH AMERICAN
STAINLESS

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 105025 02 Mail To:
A.M. CASTLE AND COMPANY
1420 KENSINGTON ROAD-SUITE 220
OAK BROOK IL 60523

Ship To:
A.M. CASTLE AND COMPANY
26800 MILES ROAD
BEDFORD HEIGHTS OH 44146

Date: 10/15/2015 Page: 1 Of 1
Steel: 630(17-4)
Finish: Hot Finish
Dia/Thk: 4.0000 in
Leg Length:
Length: 144.00 in
Corrosion:

Customer: 0032 005

NAS Order: LP 37916 1

Your Order: 346085-1

Item Code: 42464

PRODUCT DESCRIPTION:

AMS 2303F,
Round Bar, Hot Rolled, Annealed, Rough Turned
UNS S17400; EN 10204 3.1, ASTM A484/11, MACRO OK, AMS 5643T
ASTM A564/13, AMS 2303, ASME SA564-07, ASTM F899/11 (CHEM ONLY)
SOL. ANNEALED @ 1900F MIN FOR 1 HR MIN. and air cooled to RT
H900 MECH. PROPERTIES ARE CAPABILITY ONLY*

REMARKS:

COMPLIES W/REQUIREMENTS OF DFAR 252.225-7009 EU DIRECTIVE
2011/65/EU. RoHS. EAF+AOD+CC. NO WELD REPAIR. MELTED AND MFG
IN USA FREE FROM MERCURY AND LOW MELTING ALLOY CONTAMINATION

DAS

14

9-30

16/03/15

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BH50373	2090	BH50382	2018					

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W519		US	.022	.176	.09	15.38	3.02	.77	.09	.027	4.21	.020
			S %	SI %	TA %	TI %						
			.0285	.62	.0080	.0020						

MECHANICAL PROPERTIES

	1 d o i c r	HB No.	Grain No.	Ferrite %	TS-900CAP KSI	YS-900CAP KSI	El-900CAP % 4D	RA-900CAP %	RC-900CAP No.	FREQ. No.	SEV. No.
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NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS

Technical
Dept. Mgr.

ABHJEET BHAVE

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6104-005
 DATE: 16/03/015

PO / BATCH NO. 31612/142259

MATERIAL CERT REC'D. yes
 QUANTITY RECEIVED: 20
 QUANTITY INSPECTED: 20
 QUANTITY REJECTED: _____

THICKNESS ORDERED: 04.00 X 5.10
 THICKNESS RECEIVED: 04.050 X 5.230
 SHEET SIZE ORDERED: _____
 SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N ☐	
CORRECT FINISH	☐ Y ☒ N ☐	
CORROSION	☐ Y ☒ N ☐	
CORRECT GRAIN DIRECTION	☐ Y ☒ N ☐	
CORRECT MATERIAL	☐ Y ☒ N ☐	
CORRECT THICKNESS	☐ Y ☒ N ☐	
PHOTO REQUIRED	☐ Y ☒ N ☐	
CORRECT MATERIAL	☐ Y ☒ N ☐	
CORRECT REF # TO LINK CERT	☐ Y ☒ N ☐	
CORRECT MATERIAL IDENTIFICATION	☐ Y ☒ N ☐	
CORRECT M# ON THE MATERIAL	☐ Y ☒ N ☐	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☐ N ☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☐ N ☒	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW				
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D
SIZE OF TEST SAMPLE				
HARDNESS / DUROMETER READING				

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS 14</u> DATE: <u>16/03/15</u>	SIGNED OFF BY: _____ DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER